

Date: Friday, 22/08/2008 2:02:20 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : 1/4 TURN FASTNER RAIL (BLACK)

Job Number : 41592 -2

Estimate Number : 10096

P.O. Number :

This Issue : 22/08/2008 S.O. No. :

Prsht Rev. : NC

First Issue : 1/1

Type : MACHINED PARTS

Previous Run : 38022

Part Number : D103858B

Drawing Number : D1038

Project Number : N/A

Drawing Revision : B

Material :

Due Date : 16/09/2008

Qty: 100 Um: Eac

Written By :

Checked & Approved By :

Comment :

Est: E 03.05.02 Reformat; Added label KJ/RF
Est Rev: F 06-08-16 Updated Packaging Procedures JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Create white labels and bag them

2.0

D2023

Extrusion, Fastener Rail



Comment: Qty.: 1.9030 f(s)/Unit Total: 190.3000 f(s)

Extrusion, Fastener Rail

B21907

J.F. 08/09/07

3.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut extrusion D2023 to length 21.81" (+0.06/-0.00)

J.F. 08/09/08

(110)

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio and Dwg D1038-58

DIP 08/09/09

(110)

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/09/09

(110)

22/08/2008 2:02:20 PM
Life Lecocq

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Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/09/12

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/16 (110) counte

9.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 7124

Black Anodize as per Dwg D1038

C 08/09/16 (110)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive, & Inspect For Transit Damage

C 8/9/25 (100)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Anodize. Place in foam to protect anodize

C 08/09/25

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389

Batch: 14104298

2-Grind wire flush and deburr

3-Clean

C 08/09/20 (10)

27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes NO DQA: RD Date: 08/05/29

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/9/07	to 2-0	one part scrap. staking in SS wire was done too hard causing the rail to bend at ends		Scrap and Destroy no Replace Qty <u>1</u>	 08/09/29	 08/09/29		 8/9/29
		R.C. Hammer error						

NOTE: Date & initial all entries

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Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50864/28 (X)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Roll Part in foam .

3-Install red cap at each end and secure with tape.

4-Apply white labels to cardboard tubes

5-Identify and Stock

Location: _____

54

8.9/29

9x

15.0

QC21

FINAL INSPECTION/W/O RELEASE

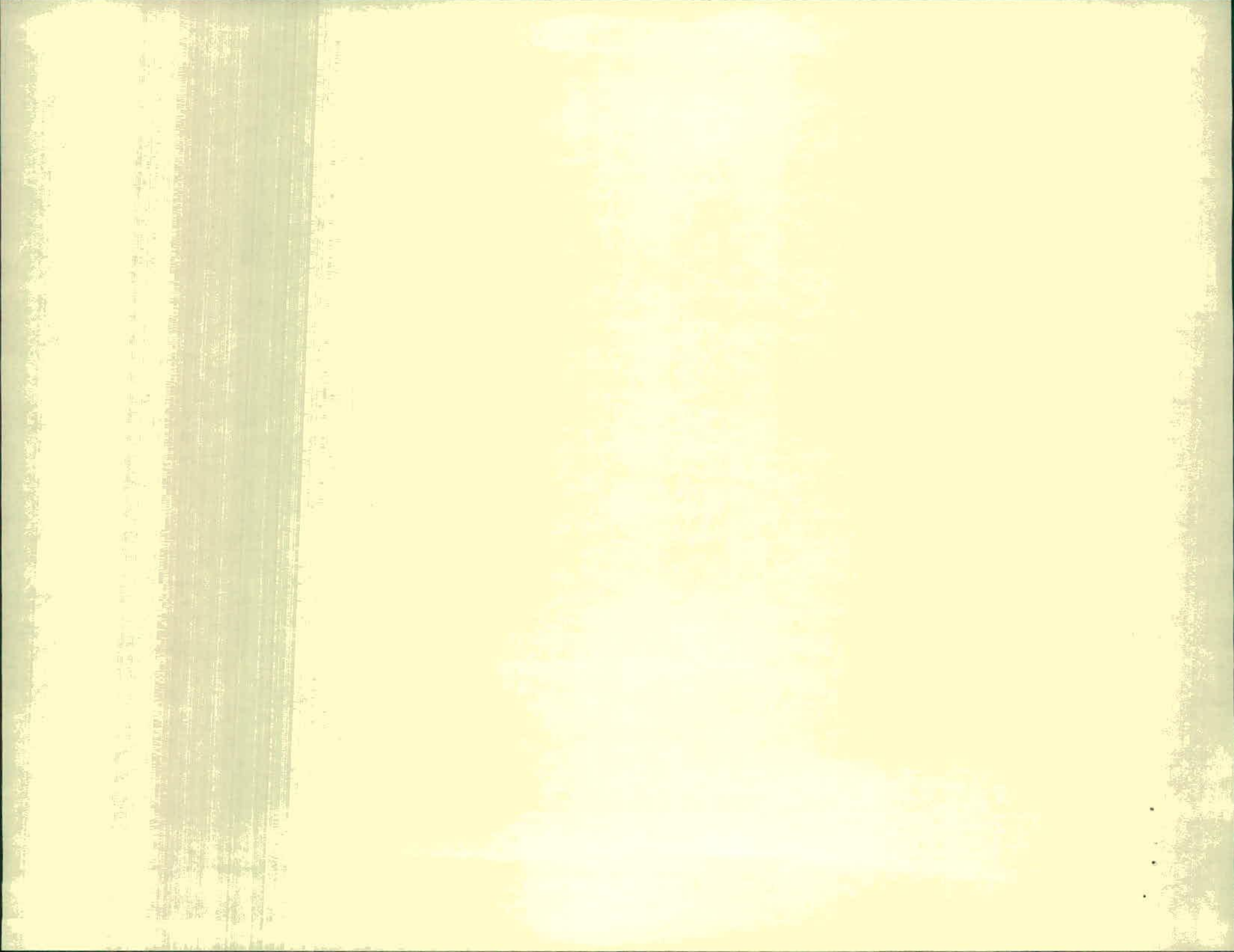


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-29

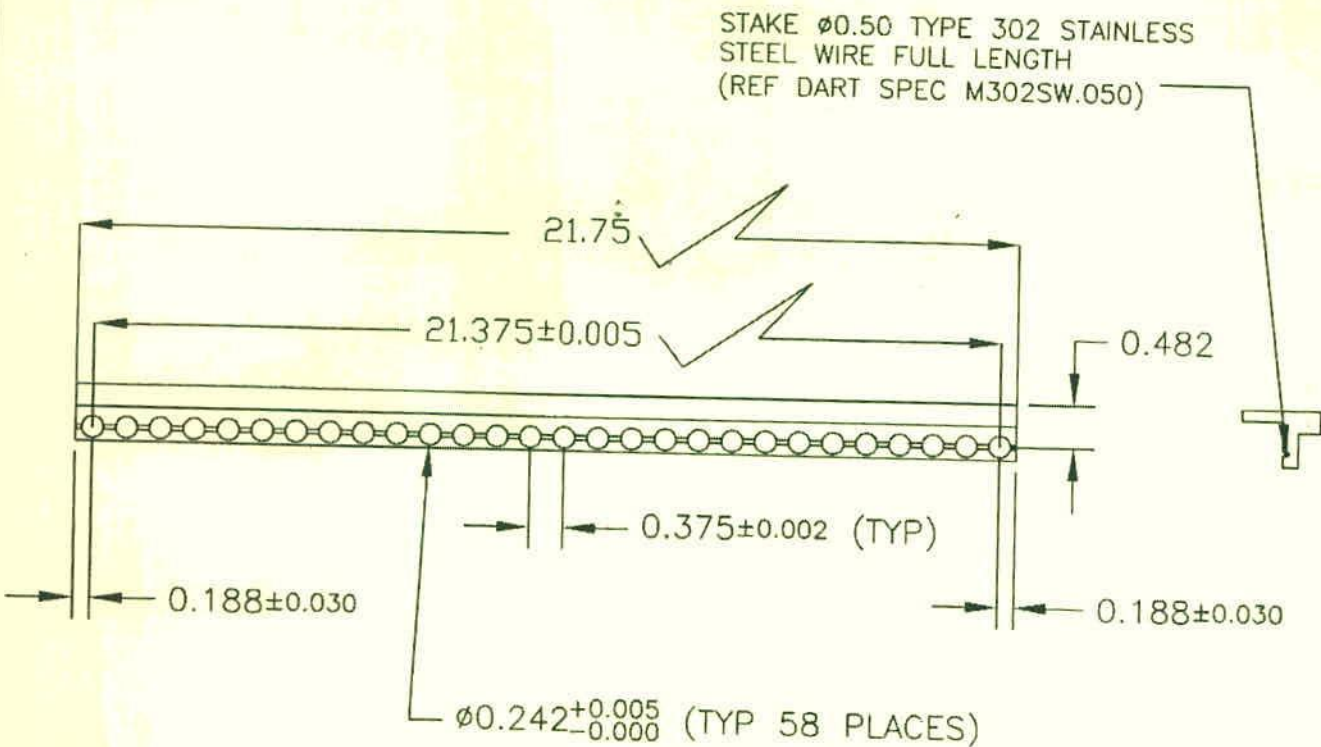


DART**DART AEROSPACE LTD**
HAMKESBURY, ONTARIO, CANADA

RELEASED

05.03.31

DESIGN	DRAWN BY	DRAWING NO.	TITLE	REV. B
4	4	D1038	1/4 TURN FASTENER RAIL	SHEET 1 OF 1
CHECKED	APPROVED			SCALE
DATE				NTS
05.02.02				
-	91.05.05	NEW ISSUE		
A	04.05.14	UPDATE TOLERANCE		
B	05.02.02	REDRAWN, UPDATE NOTES		

**D1038-58 1/4 TURN FASTENER RAIL**

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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